

Date: Wednesday, 19/12/2007 10:10:32 AM
 User: Linda Lacelle

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	WEARPLATE
Job Number	36446	Part Number	D3719041
Estimate Number	13107	Drawing Number	D3719 UNDER REVIEW
P.O. Number	N/A	Project Number	N/A
This Issue	19/12/2007	S.O. No.	N/A
Prsht Rev.	NC	Drawing Revision	U/R
First Issue	N/A	Material	N/A
Previous Run	N/A	Due Date	20/12/2007
Written By		Qty:	24
Checked & Approved By		Um:	Each
Comment	Est Rev A New Issue 07-12-19 EC		

Additional Product



Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	304/316 .063 Sheet 0.63 Comment: Qty.: 0.5933 sf(s)/Unit Total : 2.3730 sf(s) 304/316 .063 Sheet 0.080 QP 07.12.19 Batch: 105997 HB 07-12-19
2.0	WATER JET	FLOW WATER JET Comment: FLOW WATER JET 1-Cut as per Dwg D3719 Dwg Rev: A HB 07-12-19 Prog Rev: A (2) 2-Deburr if necessary HB 07-12-19
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE HB 07-12-19 Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK JAN 12.19 (2) Comment: SECOND CHECK
5.0	D30093	CUP Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s) CUP Batch: B36431 FC 07/12/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
07.12.19	1	USE 304/316 SS SHEET 0.080" THICK	N/A CP → USED 0.063	07.12.20		GP 07.12.19 P.M. QSI 042	
07.12.20	6.5	DRILL HOLES IN CUP 17/64" ($\phi 0.266$) TYP 4 PLACES				GP 07.12.20 P.M. QSI 042	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 08/01/19
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 19/12/2007 10:10:32 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 36446

Part Number: D3719041

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld D3009-3 cups as per dwg D3719

FC

2-Weld hard facing as per Dwg D3719

FC

A/R 2059B Hard Coat rod

Batch: m106390

FC 07/12/20 ②

7.0 QC9

VISUAL WELDING INSPECTION



ENGINEERED APPROVAL

Q 07.12.20 ②

Comment: VISUAL WELDING INSPECTION

QC9 -> PD 07-12-20 ②

8.0 POWDER COATING

POWDER COATING



m 105642

②

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

Bl 07-12-21

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

m 1

07/12/21

QX

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST 497

A8

07/12/28

②

11.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

D 08/01/03

Job Completion



m 2008/1/12

J

POSITIVE RECALL

EFFECTIVE 07.12.03 AUTH U
RELEASED U DATE 07.03.03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

D3719-041 PARTS LIST:

ITEM NO.	PART NUMBER	DESCRIPTION	QTY.
1	D3719-1	WEARPLATE	1
2	D3009-3	CUP	4

7

6

5

4

3

2

1

D

D

2059B HARDCOAT
(6 PLACES)0.063
TO
0.1253.25
(TYP)1.00
PITCH
(TYP)

1.50 (REF)

1.00

C

C

HARDCOAT WELD
SURFACING (REF)

D3719-1 WEARPLATE

INSTALL D3009-3 (REF) FLUSH
WITH THIS SURFACE (TYP)

(4 PLACES)

1/64

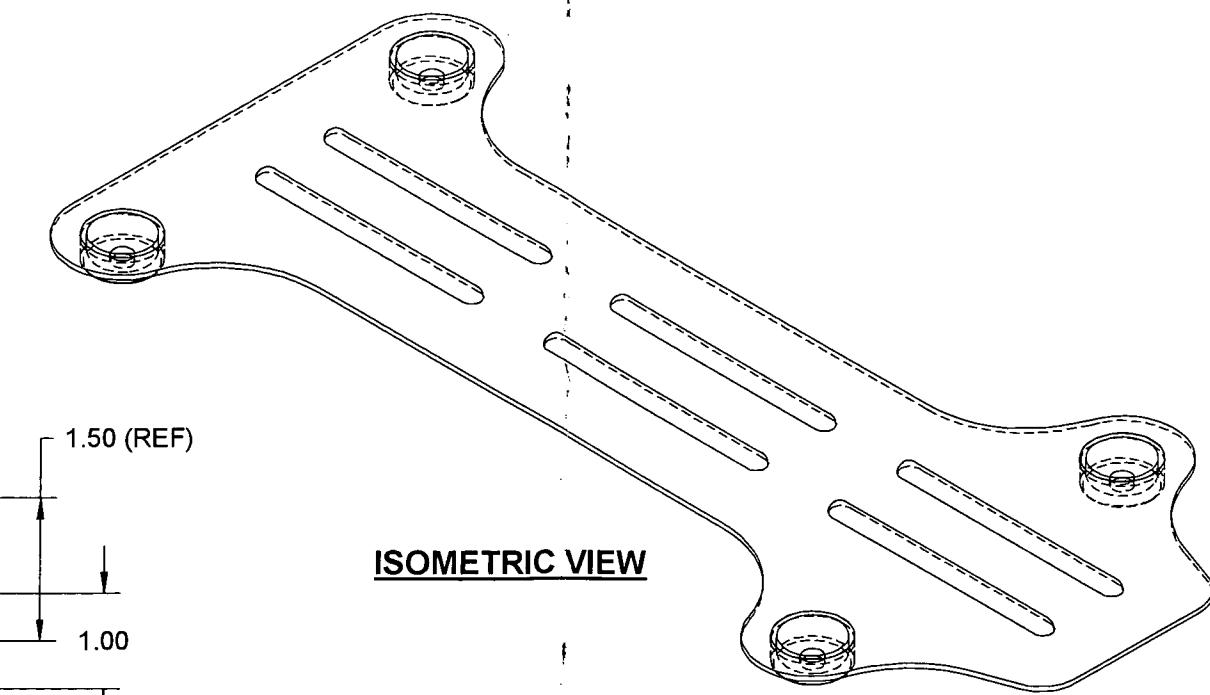
D3009-3 CUP
(4 PLACES)

1/32

CP
07.12.19D3719-041 WEARPLATE

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: POWDER COAT "GREY SANTEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3719-041" & B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.11 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE
- 9) WELD PER DART QSI 004



PRELIMINARY ISSUE *JP*
07.12.18

A	NEW ISSUE	CP	07.12.12
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>JP</i>		
DRAWN	<i>JP</i>		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.12.12	SCALE	1:2
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DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D3719
REV. A
SHEET 1 OF 2

TITLE
WEARPLATE
SCALE
1:2

8

7

6

5

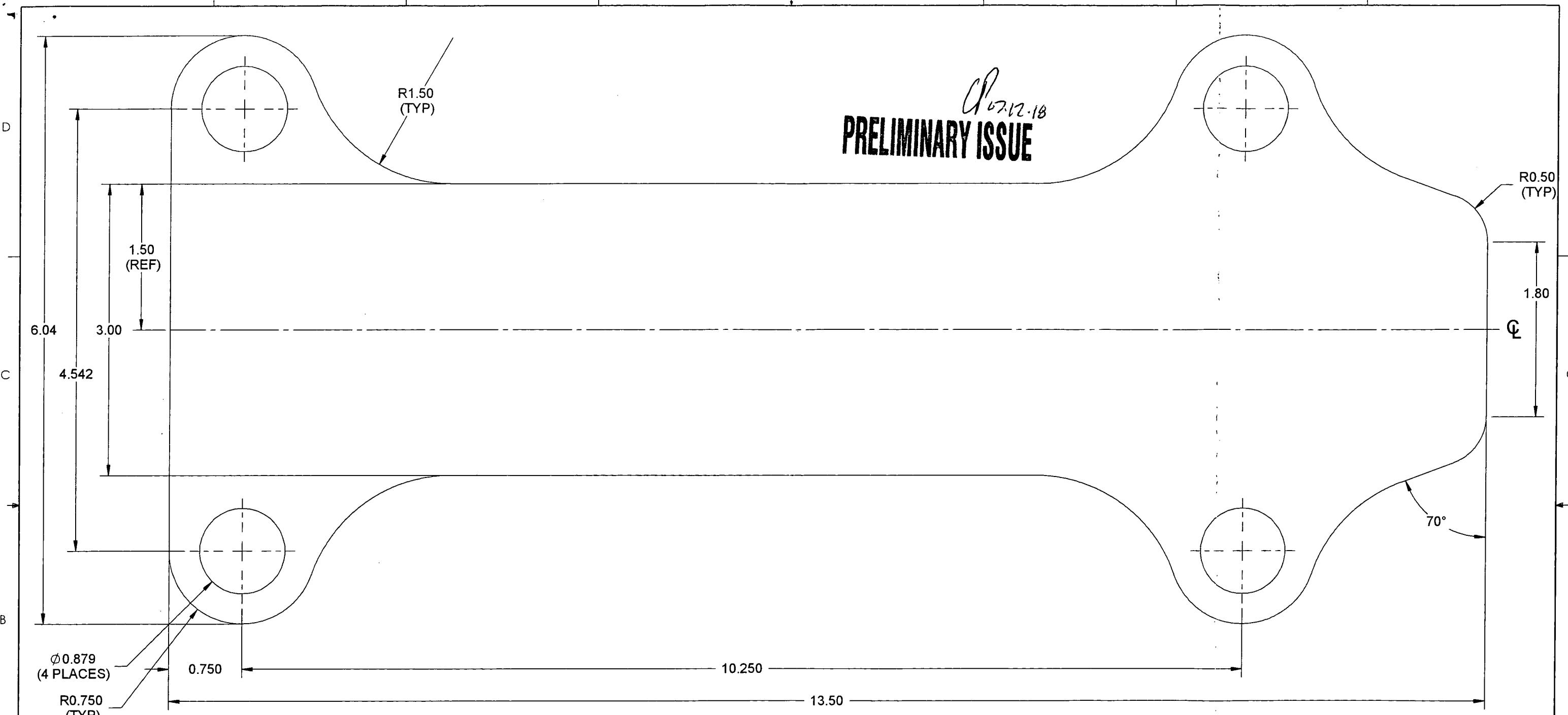
4

3

2

1

A



D3719-1 WEARPLATE

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 16 GAUGE (0.063 THICK)
(REF DART SPEC M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3719-1" & B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.38 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE

DESIGN	<i>QP</i>	DART AEROSPACE LTD
DRAWN	<i>QP</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO.
MFG. APPR.		REV. A
APPROVED		D3719
DE APPR.		SHEET 2 OF 2
DATE	07.12.12	TITLE
		WEARPLATE
		SCALE
		1:1
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DART AEROSPACE LTD	Work Order:	3446
Description: WHEEL PLATE	Part Number:	D3719
Inspection Dwg: D3719 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

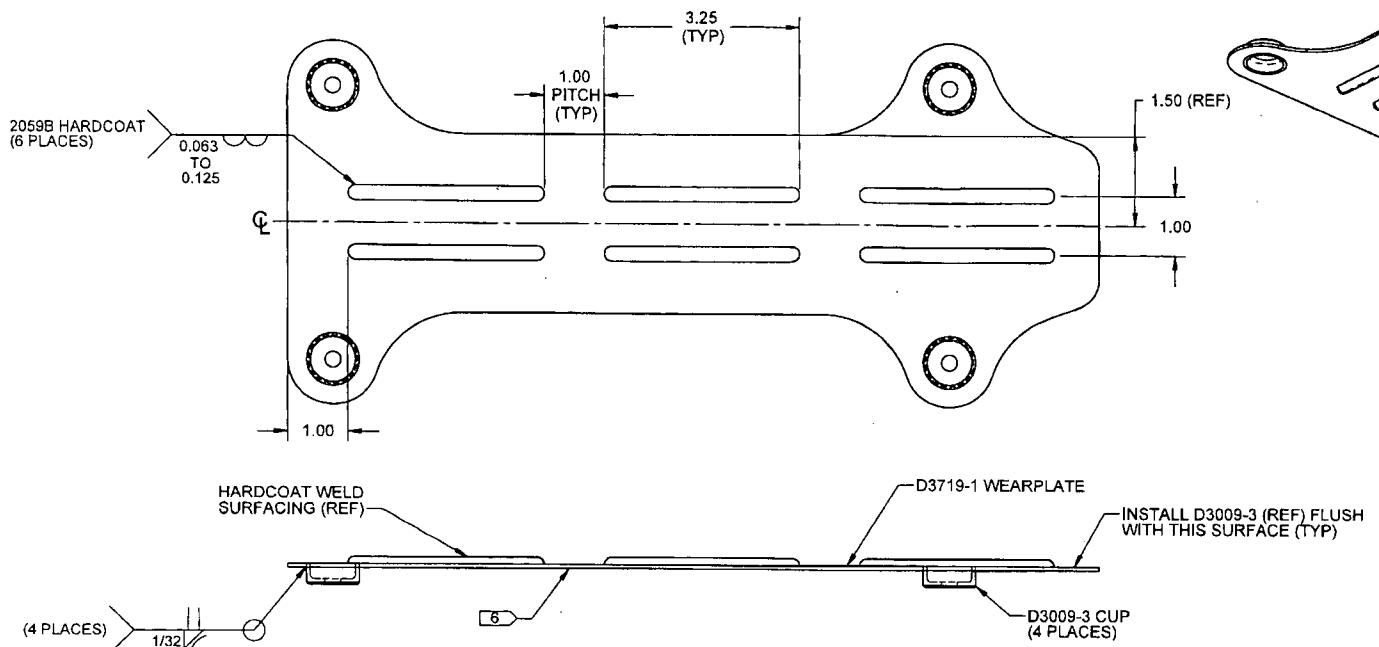
Preliminary

Measured by:	IB	Audited by:	/	Prototype Approval:	N/A
Date:	07-12-14	Date:	07-12-14	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

PARTS LIST FOR D3719-041 WEARPLATE

QTY.	PART NUMBER	DESCRIPTION
1	D3719-1	WEARPLATE
4	D3009-3	CUP



D3719-041 WEARPLATE

ISOMETRIC VIEW

SHOP COPY
RETURN TO

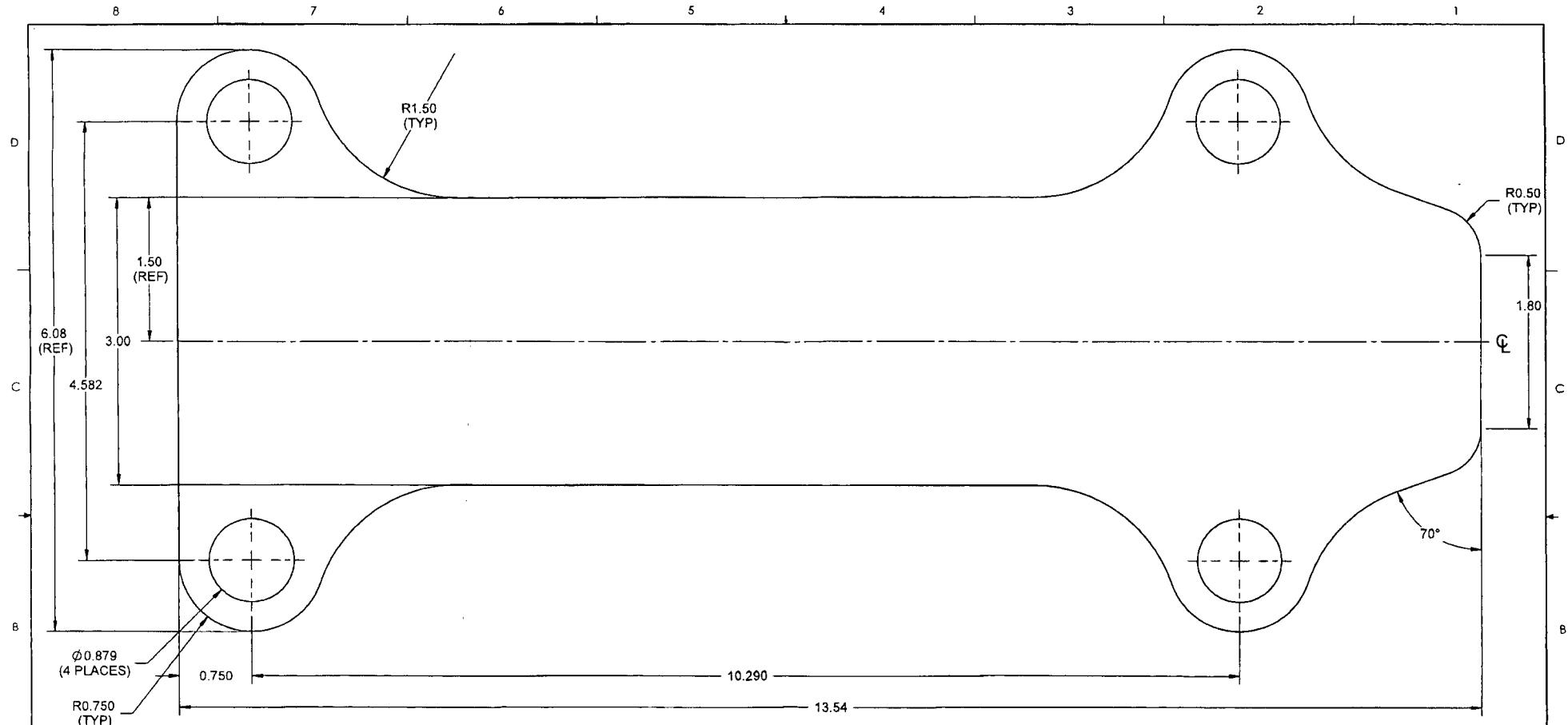
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36496

RELEASED
02-01-07 JWP

NOTES:

- 1) MATERIAL: N/A
 - 2) FINISH: POWDER COAT "GREY SANTEX" (4.3.5.6) PER DART QSI 005 4.3
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3719-041" & B/N USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 1.11 lbs
 - 8) PART IS SYMMETRIC ABOUT CENTERLINE
 - 9) WELD PER DART QSI 004

A	NEW ISSUE	CP	07.12.12
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>991</i>	DART AEROSPACE LTD	
DRAWN	<i>991</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>B3</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>B3</i>	D3719	SHEET 1 OF 2
APPROVED	<i>BB</i>	TITLE	SCALE
DE APPR.	<i>BB</i>	WEARPLATE	1:2
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D3719-1 WEARPLATE

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 16 GAUGE (.063 THICK)
(REF DART SPEC M304S16GA)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: .005 TO .010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.87 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE

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WORK ORDER
NO. 36446

DESIGN	<u>99</u>	DART AEROSPACE LTD	
DRAWN	<u>99</u>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<u>B</u>	DRAWING NO.	
MFG. APPR.	<u>W</u>	REV. A	
APPROVED	<u>W</u>	D3719	
DE APPR.	<u>W</u>	SHEET 2 OF 2	
DATE 07.12.12		TITLE	SCALE
WEARPLATE		1:1	

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09-07-07